

Work Order ID 79053

79053

Page 1

January-19-12 9:29:00 AM

Item ID: K642-511 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: saddle kit 642-511
 Start Date: 19/01/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 02/02/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/01/19 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D206-642	O

100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Create White labels per PPP K642-511	CHG004							
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP K642-511 Location:								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12/4/10 (1)

12/5/10

MLJ 12/05/10

PPP 821111

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 79053

79053

Parent Item: K642-511

K642-511

Parent Item Name: saddle kit 642-511

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A07.06.05 new issueEC
IPP Rev.B 08.02.05 , Per ECN1080P LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D206-648-013

D206-648-013

GHW Modification

Manufactured

No

110

Each

7.0000

** 1

B 8362 SP
D-5-9

Location

Loc Qty

Loc Code

FG120

2

65455

0

66633

0

71578

1

72402

1

FG125

5

75825

5

Manufactured

No

110

Each

6.0000

** 1

81620 JB SP

D2932-1

D2932-1

Saddle LH Out, 206

Location

Loc Qty

Loc Code

ST428

6

71060

1

72886

1

73466

4

Manufactured

No

110

Each

1.0000

** 1

75097 JB 12/05/09

D2933-1

D2933-1

Saddle LH In, 206

Location

Loc Qty

Loc Code

ST428

1

71062

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 79053

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Parent Item: K642-511

K642-511

Parent Item Name: saddle kit 642-511

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 1.00

Required Qty: 1.00

D2938-1
D2938-1
Saddle LH Out, 206

Manufactured No

110 Each

7.0000

1

1

**

7895728

Location

Loc Qty

Loc Code

ST428A

7

71058

1

75098

6

Manufactured No

110 Each

1.0000

1

1

**

821328

D2939-1
D2939-1
Saddle LH In, 206

Location

Loc Qty

Loc Code

ST428A

1

71056

1

Purchased No

110 Each

162.0000

8

8

**

12/05/09

AN3C41A
AN3C41A
BOLT

Location

Loc Qty

Loc Code

FG

4

103324

4

ST354

158

119324

48

119530

60

119673

50

119673

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 79053

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

79053

K642-511

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 1.00

Required Qty: 1.00

D2652
D2652
Bushing

Manufactured No

110 Each

959.0000

16

16

**

81952 JB

Location

Loc Qty

Loc Code

FG

44

31985

44

ST013

915

73834

15

73836

36

76132

64

76135

400

77135

400

MS21043-3
MS21043-3
Nut

Purchased No

110 Each

1,243.000

20

20

**

121255 JB

Location

Loc Qty

Loc Code

FG

72

103691

72

ST300

632

119901

632

ST301

539

118077

2

118614

441

118686

30

119758

66

D3672-7
D3672-7
Phenolic Washer

Manufactured No

110 Each

1,068.000

24

24

**

12105109

Location

Loc Qty

Loc Code

ST060

1068

73488

68

76279

1000

76279

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: K642-511

Parent Item Name: saddle kit 642-511

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K642-511

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 1.00

Required Qty: 1.00

AN5C11A

Purchased

No

110

Each

130.0000

8

8

✓

**

120423 JB

SP

AN5C11A

Bolt

Location

Loc Qty

Loc Code

FG

4

103715

4

ST337

126

118983

26

119127

50

119328

50

Purchased

No

110

Each

66.0000

4

4

✓

**

JB

SP

AN5C12A

AN5C12A

BOLT

Location

Loc Qty

Loc Code

FG

2

18918

2

ST338

64

118983

20

119328

44

Purchased

No

110

Each

167.0000

4

4

✓

**

119328

JB

SP

AN5C13A

AN5C13A

BOLT

Location

Loc Qty

Loc Code

ST338

167

118983

67

119537

100

Purchased

No

110

Each

0.0000

8

8

✓

**

118983

119736

JB

12/05/09

AN960C516L

NAS1149C0532

R

*AN960C516I *

WASHER

January-19-12 9:29:05 AM

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 79053

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Parent Item: K642-511

K642-511

Parent Item Name: saddle kit 642-511

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 1.00

Required Qty: 1.00

AN4C6A

Purchased

No

110

Each

364.0000

12

i2

**

120423 JB SP

AN4C6A

Bolt

Location

Loc Qty

Loc Code

FG

4

103344

4

ST356

360

116704

8

119328

152

119749

200

*D3672-3

Manufactured

No

110

Each

868.0000

24

24

**

83238 JB SP

D3672-3

Phenolic Washer

Location

Loc Qty

Loc Code

ST060

868

64176

180

73487

188

76278

500

AN960C416L

NAS1149C0432R

Purchased

No

110

Each

0.0000

24

24

**

117291 JB SP 12/05/09

*AN960C416I *

WASHER

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 79053

79053

Parent Item: K642-511

K642-511

Parent Item Name: saddle kit 642-511

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

110

Each

1,035.000

13

13

**

121162

JB

MS21043-4

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST300

470

118686

470

ST301

525

119309

29

119546

496

Manufactured

No

110

Each

20.0000

1

1

**

79232

JB 2/05/09

D3407-043

D3407-043

Tow Ring

Location

Loc Qty

Loc Code

ST463

18

68339

2

72513

1

74519

15

ST464

2

68339

0

71040

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 79053

79053

Parent Item: K642-511

K642-511

Parent Item Name: saddle kit 642-511

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 1.00

Required Qty: 1.00

D3456-1

Manufactured No

110

Each

72.0000

1
**

1 ✓

81876 JB

D3456-1

Washer

Location

Loc Qty

Loc Code

FG

7

25701

7

ST034

50

77486

50

ST044

15

66848

3

71165

2

73493

10

Manufactured No

110

Each

1,372.000

10
**

10 ✓

79585 JB

D2712

D2712

Set Screw

Location

Loc Qty

Loc Code

FG

50

29962

50

ST021

1322

76065

1322

Manufactured No

110

Each

36.0000

2
**

2 ✓

81977 JB 12/05/09

D3457-1

D3457-1

Washer

Location

Loc Qty

Loc Code

FG

10

32409

10

ST044

26

67779

1

76231

25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: K642-511

Parent Item Name: saddle kit 642-511

79053

K642-511

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 1.00

Required Qty: 1.00

D2934
D2934
Saddle Spacer

Manufactured No

110 Each

52.0000

2 2 ✓

**

78802 JB SP

Location

Loc Qty

Loc Code

FG

6

31929

6

ST021

46

74501

11

74883

35

Manufactured No

110 Each

48.0000

2 2 ✓

**

78807 JB SP

Location

Loc Qty

Loc Code

FG

6

31793

6

ST021

42

74503

12

74882

30

Purchased No

110 Each

114.0000

9 9 ✓

**

121276 JB SP 12/05/09

Location

Loc Qty

Loc Code

FG

4

101261

4

ST353

110

116590

0

119083

2

119324

92

119530

16

AN3C36A
AN3C36A
BOLT

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Parent Item: K642-511

Parent Item Name: saddle kit 642-511

79053

K642-511

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C35A

Purchased

No

110

Each

96.0000

3

3

**

121313

JB

AN3C35A

BOLT

Location

Loc Qty

Loc Code

FG

4

18914

4

ST353

92

119125

42

119449

50

AN960C101

NAS1149C0332

Purchased

No

110

Each

0.0000

24

24

**

121509 JB

***AN960C101 ***

washer

D3396-3

Manufactured

No

110

Each

63.0000

2

2

**

JB

D3396-3

Spacer

Location

Loc Qty

Loc Code

FG

10

26772

10

ST041

53

73349

53

D3672-1

Manufactured

No

110

Each

942.0000

24

24

**

73349

JB 12/05/09

D3672-1

Phenolic Washer

Location

Loc Qty

Loc Code

FP001

306

66821

306

ST060

636

72229

136

76277

500

76277

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: K642-511

K642-511

Parent Item Name: saddle kit 642-511

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 1.00

Required Qty: 1.00

AN5C35A

Purchased

No

110

Each

63.0000

1

1

**

AN5C35A

Bolt

Location

Loc Qty

Loc Code

ST340

63

108407

13

118451

25

119749

25

118451

AN5C15A

Purchased

No

110

Each

61.0000

1

1

**

AN5C15A

Bolt

Location

Loc Qty

Loc Code

ST338

61

118191

3

118267

33

119749

25

AN5C32A

Purchased

No

110

Each

93.0000

2

2

**

AN5C32A

Location

Loc Qty

Loc Code

FG

4

18918

4

ST339

89

117407

25

117969

14

119035

50

1x 117407

1x 119035

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: K642-511

Parent Item Name: saddle kit 642-511

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K642-511

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 1.00

Required Qty: 1.00

AN5C34A

Purchased

No

110

Each

63.0000

2

2

**

AN5C34A

Location

Loc Qty

Loc Code

FG

2

18918

2

ST339

61

118985

11

119083

20

119530

30

110

Each

581.0000

4

4

**

MS21043-5

Purchased

No

MS21043-5

Nut

Location

Loc Qty

Loc Code

FG

20

101418

20

ST300

136

112314

136

ST301

425

116548

100

118159

100

119307

25

119537

200

118159

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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4.7 206L/L-1/L-3/L-4/407 HIGH GEAR FLOAT SKIDTUBES (TRI-BAG COMPATIBLE)

ITEM	QTY -511	QTY -512	QTY -515	QTY -516	QTY -541	QTY -547	QTY -549	QTY -551	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-511	SKIDTUBE INSTALLATION, LH
		X								D206-642-512	SKIDTUBE INSTALLATION, RH
			X							D206-642-515	SKIDTUBE INSTALLATION, LH
				X						D206-642-516	SKIDTUBE INSTALLATION, RH
1	1	1			X					D206-642-541	SKIDTUBE
						X				D206-642-547	WEARSHOE KIT (REPLACES -543 KIT)
							X			D206-642-549	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-551	SKIDTUBE
	1	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D3274-041	SKIDTUBE ASSEMBLY
1								1		D4362-041	SKIDTUBE ASSEMBLY
3					1			1		D2646	* AFT CAP ⁽¹⁾
4					2			2		AN3C4A	* BOLT ⁽¹⁾
5A					2			2		NAS1149C0332R	* WASHER ⁽¹⁾ (OR AN960C10L)
5B					2			2		D3672-1	* WASHER (REPLACES NAS1515H3L) ⁽¹⁾
6	1		1							D2932-1	SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7	1		1							D2933-1	SADDLE, FWD IN, LH
7		1		1						D2933-2	SADDLE, FWD IN, RH
8	1		1							D2938-1	SADDLE, AFT OUT, LH
8		1		1						D2938-2	SADDLE, AFT OUT, RH
9	1		1							D2939-1	SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3C41A	BOLT
11	16	16	16	16						D2652	BUSHING
12A	8	8	8	8						MS21043-3	NUT
12B	16	16	16	16						D3672-7	WASHER (REPLACES NAS1515H5) ⁽¹⁾
13	4	4	4	4						AN5C11A (or AN5C12A)	* BOLT ⁽²⁾
14	4	4	4	4						AN5C11A (or AN5C13A)	* BOLT ⁽²⁾
15A	8	8	8	8						NAS1149C0532R	WASHER (OR AN960C516L)
15B	8	8	8	8						D3672-7	WASHER (REPLACES NAS1515H5L) ⁽¹⁾
16	12	12	12	12						AN4C6A	BOLT
17A	24	24	24	24						D3672-3	WASHER (REPLACES NAS1515H4L) ⁽¹⁾
17B	24	24	24	24						NAS1149C0432R	WASHER (OR AN960C416L)
18	12	12	12	12						MS21043-4	NUT
20A					9	9				D3537-1	* WEARPAD ⁽¹⁾ (REPLACES D2648-3)
21A					1	1				D3537-3	* WEARPAD ⁽¹⁾ (REPLACES D3429-1)
22A					1	1				D3535-15	* WEARSHOE ⁽¹⁾ (REPLACES D2656-15)
22B					1	1				D3536-15	* GASKET ⁽¹⁾
23A					1	1				D3535-23	* WEARSHOE ⁽¹⁾ (REPLACES D2656-23)
23B					1	1				D3536-23	* GASKET ⁽¹⁾
24A					1	1				D3535-39	* WEARSHOE ⁽¹⁾ (REPLACES D3287-1)
24B					1	1				D3536-39	* GASKET ⁽¹⁾
25A					1	1				D3535-35	* WEARSHOE ⁽¹⁾ (REPLACES D2656-35)
25B					1	1				D3536-35	* GASKET ⁽¹⁾
26A			8	8	78	78	8			AN3C4A	* BOLT ⁽¹⁾
26B			8	8	78	78	8			NAS1149C0332R	* WASHER ⁽¹⁾ (OR AN960C10L)
26C			8	8	78		8			ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D3407-043	TOW RING
32A	1	1	1	1						D3456-1	WASHER
32B	2	2	2	2						D3457-1	WASHER
33	1	1	1	1						MS21043-4	NUT
34			1	1	1					AN4C5A	BOLT
35			1	1	1					NAS1149C0463R	WASHER (OR AN960C416)
36			1	1	1					D3413-1	RING
37	10	10	10	10						D2712	SET SCREW
38	2	2	2	2						D2934	SADDLE SPACER
39	2	2	2	2						D2935	SADDLE SPACER

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ITEM	QTY -511-	QTY -512	QTY -515	QTY -516	QTY -541	QTY -547	QTY -549	QTY -551	QTY -013	PART NUMBER	DESCRIPTION
40									2	D3414-041	LUG ASSEMBLY (GHW)
41									4	AN3C37A	BOLT
42									8	D2652	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN960C10)
50	9	9	3	3						AN3C36A	BOLT
51	3	3	3	3						AN3C35A	BOLT
52	24	24	12	12						NAS1149C0332R	WASHER (OR AN960C10L)
53	24	24	12	12						D3672-1	WASHER (REPLACES NAS1515H3L)
54	12	12	6	6						MS21043-3	NUT
55	2	2	2	2						D3396-3	SPACER
56A	1	1	1	1						AN5C35A	BOLT
56B	1	1	1	1						AN5C15A	BOLT
60	2	2	2	2						AN5C32A	BOLT
61	2	2	2	2						AN5C34A	BOLT
62	4	4	4	4						MS21043-5	NUT
80							1	1		D4368-041	FWD WEARPLATE ASSY
81							1	1		D4368-043	AFT WEARPLATE ASSY
82A							1	1		D4383-1	WEARPAD
82B							1	1		D4383-3	WEARPAD
83							20	20		D3873-3	BUSHING
84								24		D3411-3	WASHER
85							2			D3275-1	SPACER
86A							6	6		AN3C40A	BOLT
86B							2	2		AN3C37A	BOLT
86C							2	2		AN3C36A	BOLT
87							10	10		MS21043-3	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D3274-041 OR D4362-041 ASSEMBLY ABOVE
(2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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